

Date: Tuesday, 8/14/2007 6:28:53 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 33885		
Estimate Number	: 10227		
P.O. Number	: <i>N/A</i>	Part Number	: D2151
This Issue	: 8/14/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2151 REV B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28280	Material	: <i>N/A</i>
Written By	: <i>[Signature] 07-08-14</i>	Due Date	: 8/21/2007 Qty: 50 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est C 00.10.23 Re-format (mpp 2101) EC Est Rev:D 06-04-28 Manufactured on Water Jet JLM Est Rev:E 06-11-24 As per Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0368 sf(s)/Unit Total : 1.8375 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)

Batch: *M103039* *18 07-08-14*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2151

Dwg Rev: *B*Prog Rev: *B**18 07-08-14*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*18 07-08-14*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/08/15 (X52)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

ML 07/08/20 *(X53)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33885

Part Number: D2151

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



53X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. A.

07/08/22

7.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



m105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/08/24

53

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



53X

Comment: INSPECT POWDER COAT

M. A.

07/08/25

9.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 17

FL

7/8/27

53

10.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



53

Comment: FINAL INSPECTION/W/O RELEASE

07/08/27

u 07-08-27

Job Completion



DART AEROSPACE LTD		Work Order:	33285
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	*			
Ø0.171	+0.005/-0.000	.171	*			
0.231	+/-0.010	.231	*			
1.217	+/-0.010	1.217	*			
2.194	+/-0.010	2.195	*			
2.300	+/-0.010	2.303	*			
1.560	+/-0.010	1.560	*			
0.250	+/-0.010	.250	*			
1.328	+/-0.010	1.328	*			
0.342	+/-0.010	.342	*			
0.740	+/-0.010	.740	*			
2.050	+/-0.010	2.050	*			
0.040	+/-0.010	.040	*			

Measured by:	JB	Audited by:	En	Prototype Approval:	N/A
Date:	07-08-14	Date:	07/08/15	Date:	N/A

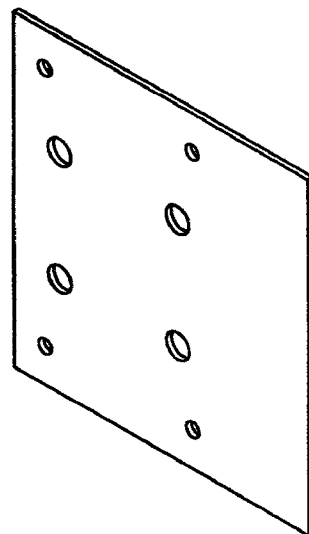
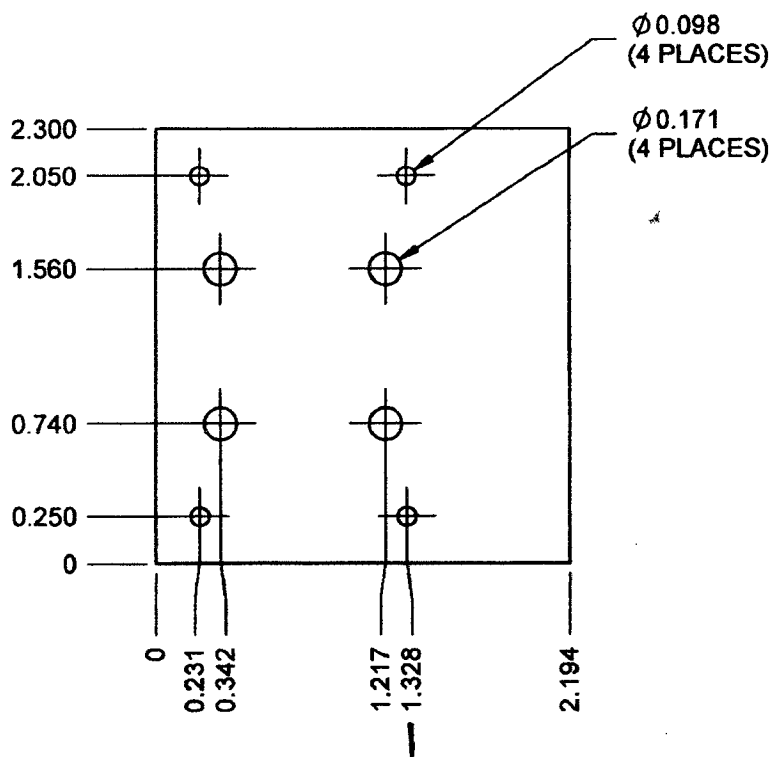
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	JB



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED

06.11.20 **[Signature]**



D2151 PACKER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 1995 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.